

Date: Wednesday, 3/12/2008 1:41:40 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STRUT |
| Job Number | : 37849 | | |
| Estimate Number | : 10219 | | |
| P.O. Number | : | Part Number | : D219923 |
| This Issue | : 3/12/2008 S.O. No. : | Drawing Number | : D2199 REV. E1 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : SMALL /MED FAB | Drawing Revision | : E1 |
| Previous Run | : 29387 | Material | : |
| Written By | : | Due Date | : 3/31/2008 Qty: 5 Um: Each |
| Checked & Approved By | : <u>JA 08 03 12</u> | | |
| Comment | : Est:D 02.06.10 Rem polish & add finish NG/CC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 2.3100 f(s)/Unit Total : 11.5500 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No:

M107245

SB 08/03/17

(5)

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 08/03/17

(5)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

CB 08/03/18

(5)

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

08/03/18 (X)

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M107005

BL 08-03-19

(5)

| | | |
|-----|-----|---|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT

M107005

08/03/19 (5X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/20
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:41:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 37849

Part Number: D219923

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51264

Po 8/3/19 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 02/03/00 (5)

Job Completion



2008/3/19 (5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

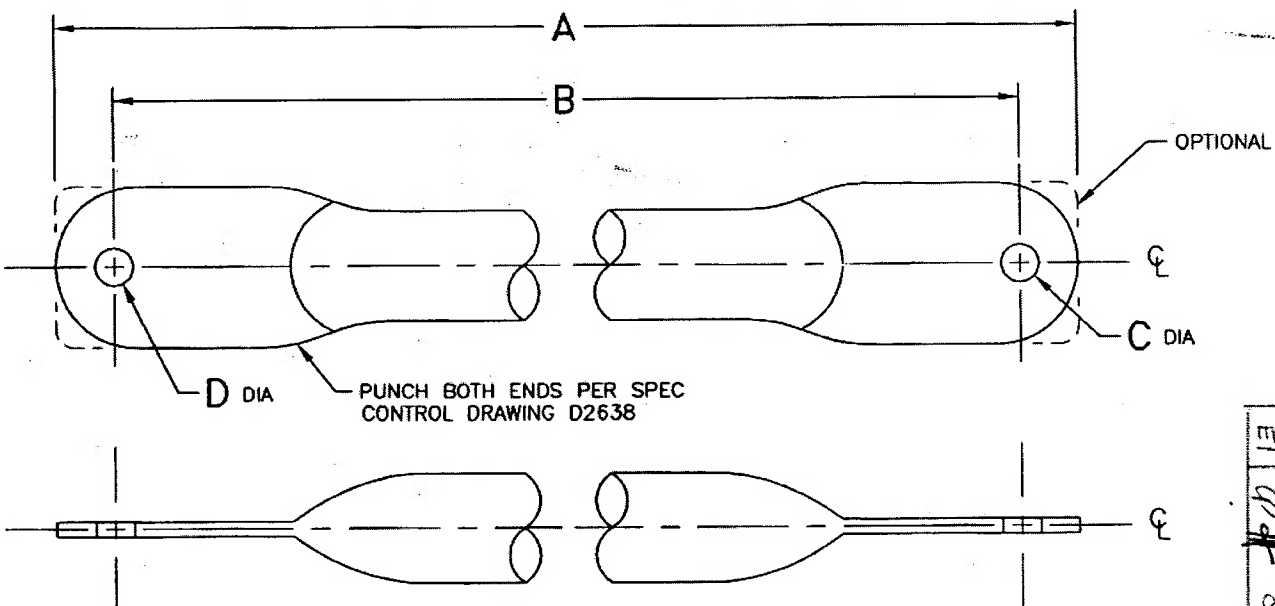
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

RELEASED
48.05.05 KE




| | A | B | C | D |
|----------|-------|-------|-------|-------|
| 02199-1 | 18.30 | 17.50 | 0.257 | 0.257 |
| 02199-3 | 5.80 | 5.00 | 0.257 | 0.257 |
| 02199-5 | 22.64 | 21.84 | 0.257 | 0.316 |
| 02199-7 | 14.74 | 13.94 | 0.257 | 0.257 |
| 02199-9 | 16.52 | 15.72 | 0.257 | 0.257 |
| 02199-11 | 23.60 | 22.80 | 0.257 | 0.316 |
| 02199-13 | 15.96 | 15.16 | 0.257 | 0.257 |
| 02199-15 | 17.57 | 16.77 | 0.257 | 0.257 |
| 02199-17 | 28.05 | 27.25 | 0.257 | 0.316 |
| 02199-19 | 18.90 | 18.10 | 0.257 | 0.257 |
| 02199-21 | 10.80 | 10.00 | 0.257 | 0.257 |
| 02199-23 | 26.18 | 25.38 | 0.257 | 0.316 |
| 02199-25 | 19.93 | 19.13 | 0.257 | 0.257 |
| 02199-27 | 27.34 | 26.54 | 0.257 | 0.316 |
| 02199-29 | 21.11 | 20.31 | 0.257 | 0.257 |

B
 B
 B
 C
 C
 D
 E
 E

* 00.10.13
 (P 00.10.13)

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE 0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER PART QSI 005 4.3 

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37849

| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| | | D2199 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 98.04.28 | | STRUT DETAILS | NTS |
| A | 1993 | NEW ISSUE | |
| B | | ADDED -11, -13, AND -15 | |
| C | | ADDED -17 AND -19 | |
| D | | ADDED -21 | |
| E | 98.04.28 | ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD | |
| E1 | 98.04.28 | ADD FINISH | |

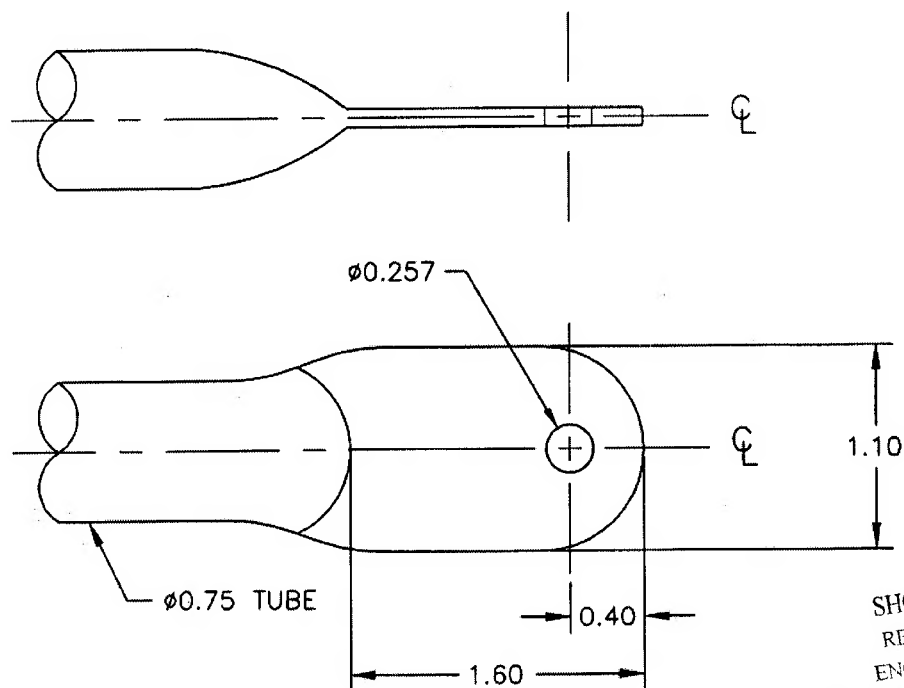
Copyright 1993 by DART AEROSPACE LTD



| | | | |
|------------------|------------------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED MJB | APPROVED KE | DRAWING NO. D2638 | REV. A SHEET 1 OF 1 |
| DATE 98.04.28 | TITLE PUNCH DT8117 SPEC CONTROL | | SCALE 1:1 |
| A | 98.04.28 | NEW ISSUE | |

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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WORK ORDER
NO. 37849